

# Work Order ID 60169-2

June 28, 2010 12:02:47 PM

shp July 15



Page 1

Item ID: D4134-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate, RH Aft

Start Date: 6/28/10 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-6-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D4134

A

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

304.00

1-Cut D4134-1F as per Dwg D4134

Dwg Rev:

Prog Rev:

2-Deburr if necessary

Deburr M.P. 10/06/29 (3x)

B10-6-29

(3)

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

B10-6-29

120



QC

QC8- Inspect parts - second check

0.00

Memo

0.00

Quality Control

8/10/6/30

(+3)

Design Change

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## WORK ORDER CHANGES

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
14.10.06	100	Design changed. PARTS NO LONGER CORRECT	W 10/10/07 JST	SCRAP 9/10.10.06 NEW PARTS MADE TO REV. B	W 10.10.06	S 10/10/07	W 10/10/07 JST	B 10.10.07

NOTE: Date & initial all entries

# Work Order ID 60169

June 28, 2010 12:02:48 PM

Page 2

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130



Brake NC

Form as per dwg  
NC BRAKE

0.00

Memo

BOY

0.00

I- Form using DT Die as per Dwg D4134

DT 9641

SB 10/07/13

3

1007.13 - as only

PTD

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Q 10.07.14 1

150



Large Fab

Large Fab

Weld per dwg A/R Hardcoat S.S. Batch: \_\_\_\_\_  
Large Fab

0.00

Memo

0.00

Weld hard surface using DT as per QSI 004 and Dwg D4134



W/O: 60169-2

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/07/13	130	add to open one hole to match the jig	SA	10/07/13	③	10.04.13 QSI 012	

Part No: D4134-042 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date &amp; initial all entries

**Work Order ID 60169**

June 28, 2010 12:02:48 PM



Page 3

Item ID: D4134-042

Revision ID:

Item Name: Wearplate, RH Aft

Start Date: 6/28/10

Start Qty: 2.00

Required Date: 7/15/10

Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
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June 28, 2010 12:02:48 PM



Page 4

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Start Date: 6/28/10 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

200

0.00



Small Fab

Memo

0.00

Small Fab

1- Bond D4134-3 gasket to inner surface of wearplate using a thin layer of 3M 1300/1300L scotch grip adhesive  
Batch: \_\_\_\_\_

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control



W/O:		WORK ORDER CHANGES					
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June 28, 2010 12:02:48 PM



Page 5

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Required Date: 7/15/10 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220



Packaging

Packaging

Identify as per dwg & Stock Location: \_\_\_\_\_

Packaging

Memo

0.00

0.00

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

LMF  
10-10-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

June 28, 2010 12:02:46 PM

Page 1

Work Order ID: 60169

Parent Item: D4134-042

Parent Item Name: Wearplate, R11 Aft





Start Date: 6/28/10

Required Date: 7/15/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.25 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4134-3 		Manufactured	No			200	Each	0.0000	1	2			
Gasket M304S18GA 		Purchased	No			100	SF	132.8779	1.5825	3.331579	4.8		
304/316 .050 Sheet													

Location

Loc Qty

Loc Code

MAT20

132.8779

111743

8.86

112885

28.0179

113062

96

113062

1810-6-29

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order: 66169
Description: WEAR PLATE RH. AFT.		Part Number: D4134-042
Inspection Dwg: D4134-1 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.300	±.010	.303	X			
.300	±.010	.303	X			
.415	±.010	.412	✓			
.82	±.030	.816	X			
2.74	±.030	2.735	X			
4.65	±.030	4.640	X			
5.055	±.010	5.053	X			
5.47	±.030	5.468	X			
φ .203	+0.005 -0.001	.205	X			
.375	±.010	.374	X			
5.85	±.030	5.85	X			
8.249	±.010	8.250	✓			
13.10	±.010	13.170	✓			
15.85	±.030	15.85	X			
18.092	±.010	18.092	X			
23.03	±.010	23.013	X			
25.85	±.030	25.85	✓			
27.934	±.010	27.934	X			
28.31	±.030	28.310	X			
8.05	±.030	8.048	X			
15.73	±.030	15.73	X			
15.98	±.030	15.98	✓			
.050	±.010	.050				

Part Dim AFT 5.47  
G. J. J. J.

Measured by: LB	Audited by: S	Prototype Approval: N/A
Date: 10-6-29	Date: 10/6/30	Date: N/A
Rev A	Date	Change
		New Issue
Revised by: KJ/JLM	Approved	

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

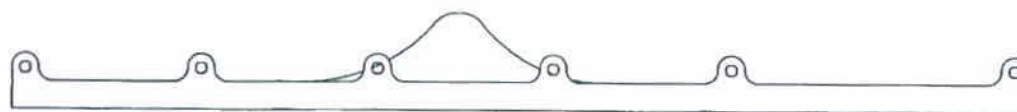
WITHOUT NOTICE

WORK ORDER

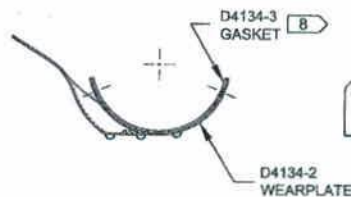
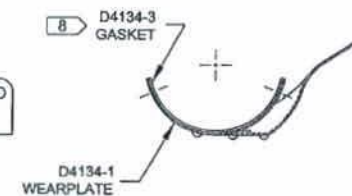
NO. 60169

PS 10-6-29

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D4134-041	WEARPLATE, LH AFT
	X	D4134-042	WEARPLATE, RH AFT
1		D4134-1	WEARPLATE
1	1	D4134-2	WEARPLATE
1	1	D4134-3	GASKET
A/R	A/R	1300 / 1300L	3M SCOTCH-GRIP ADHESIVE



D4134-041 WEARPLATE, LH AFT



D4134-042 WEARPLATE, RH AFT

**RELEASED**  
2010-06-23

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART Q8 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4134-xxx" USING YELLOW PAINT MARKER ON INSIDE SURFACE
- 7) WEIGHT: -041/-042 = 2.2 lbs
- 8) BOND D4134-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

REV.	NEW ISSUE	DESCRIPTION	CP	10.06.15
DESIGN	99	DART AEROSPACE USA, INC	BY	DATE
DRAWN	99	PORT HADLOCK, WA		
CHECKED	99	DRAWING NO.	REV. A	
MFG. APPR.	99	D4134	SHEET 1 OF 6	
APPROVED	99	TITLE	SCALE	
DE APPR.	99	WEARPLATE, AFT	NTS	
DATE	10.06.15	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

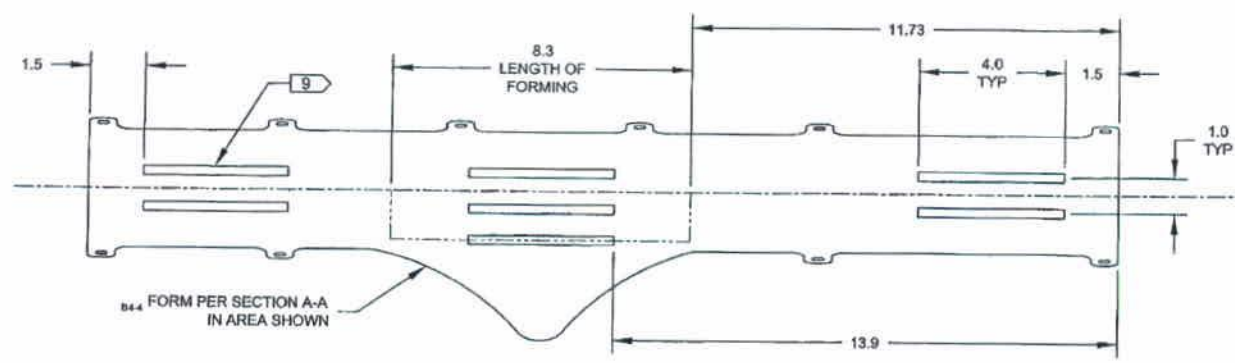
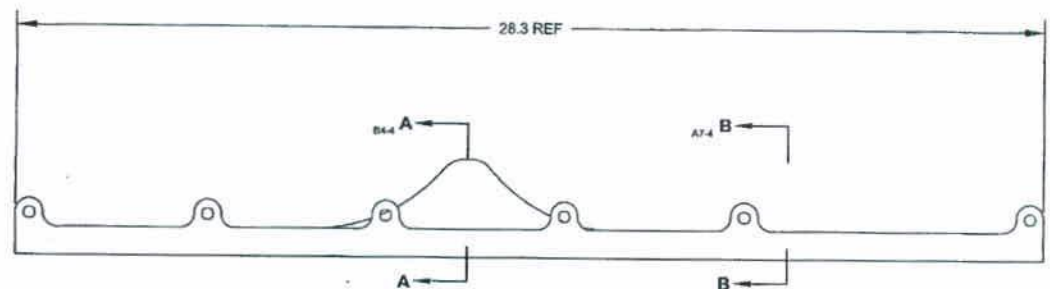
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1



**D4134-1 WEARPLATE, LH**

- NOTES:**
- 1) MATERIAL: MAKE FROM D4134-1F
  - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 1.8 lbs
  - 8) WELD PER QSI 004
  - 9) 2059B HARDCOAT WELDS, 0.083 TO 0.125 HIGH

*w/o 60169*

**RELEASED**  
2010-06-23  
*JH*

DESIGN	42	<b>DART AEROSPACE USA, INC</b>	
DRAWN	41	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4134	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE, AFT	NTS
DATE	10.06.15	COPYRIGHT © 2016 BY DART AEROSPACE USA, INC	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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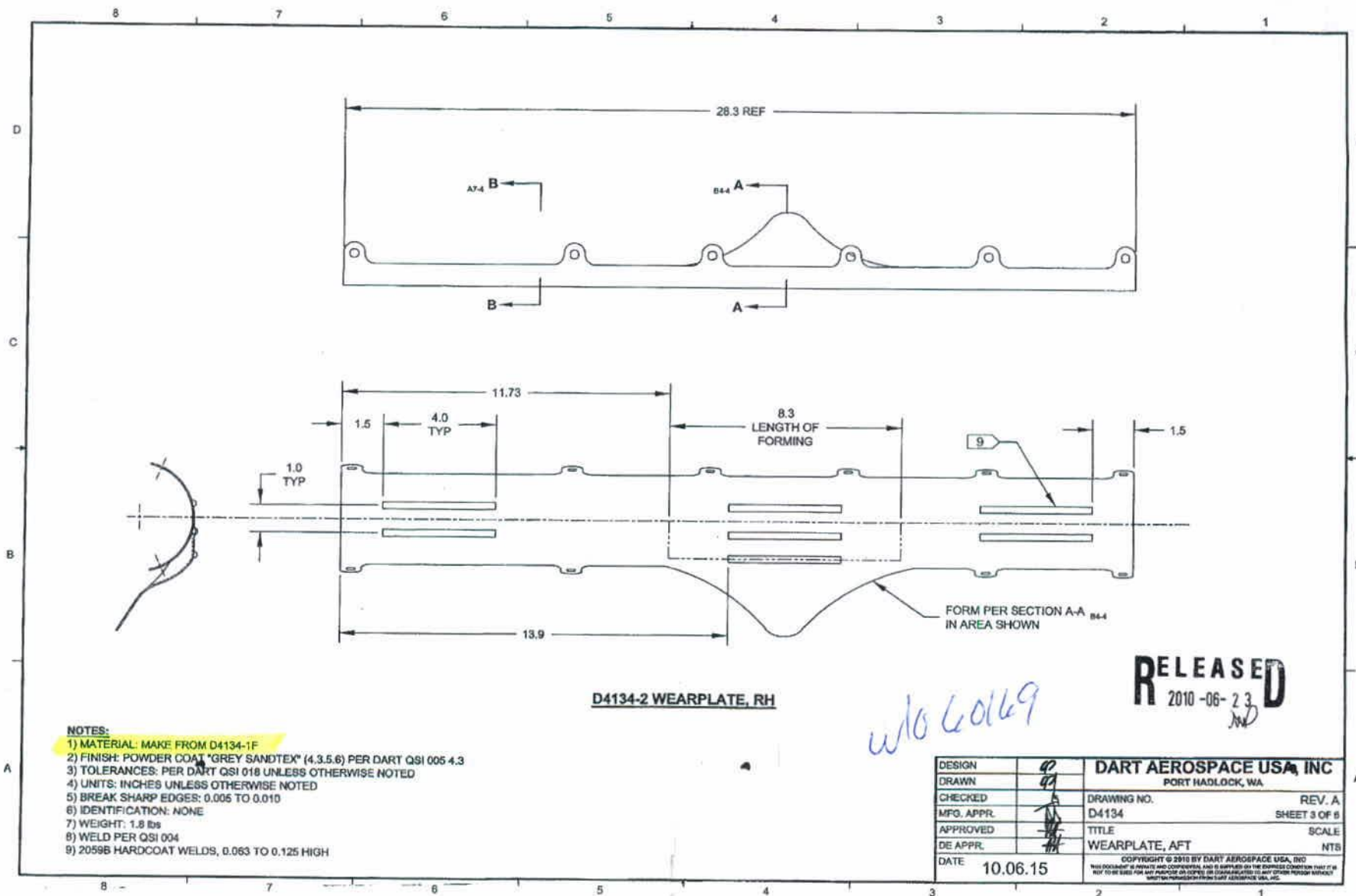
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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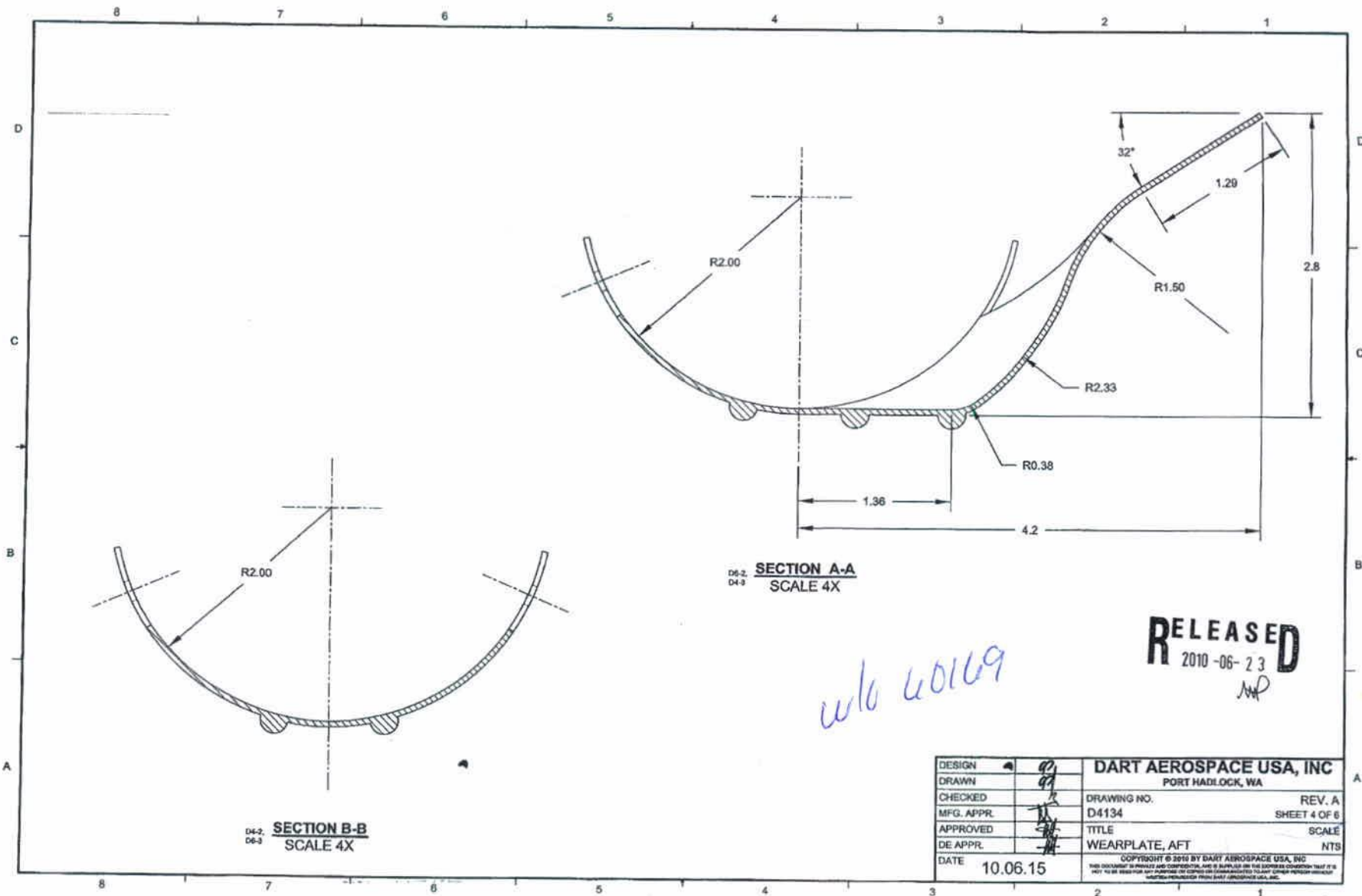
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w/o 40169

RELEASED  
2010-06-23  
ND

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D4134	SHEET 4 OF 6
APPROVED	91	TITLE	SCALE
DE APPR.	91	WEARPLATE, AFT	NTS
DATE	10.06.15	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC	
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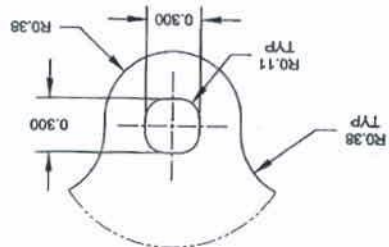
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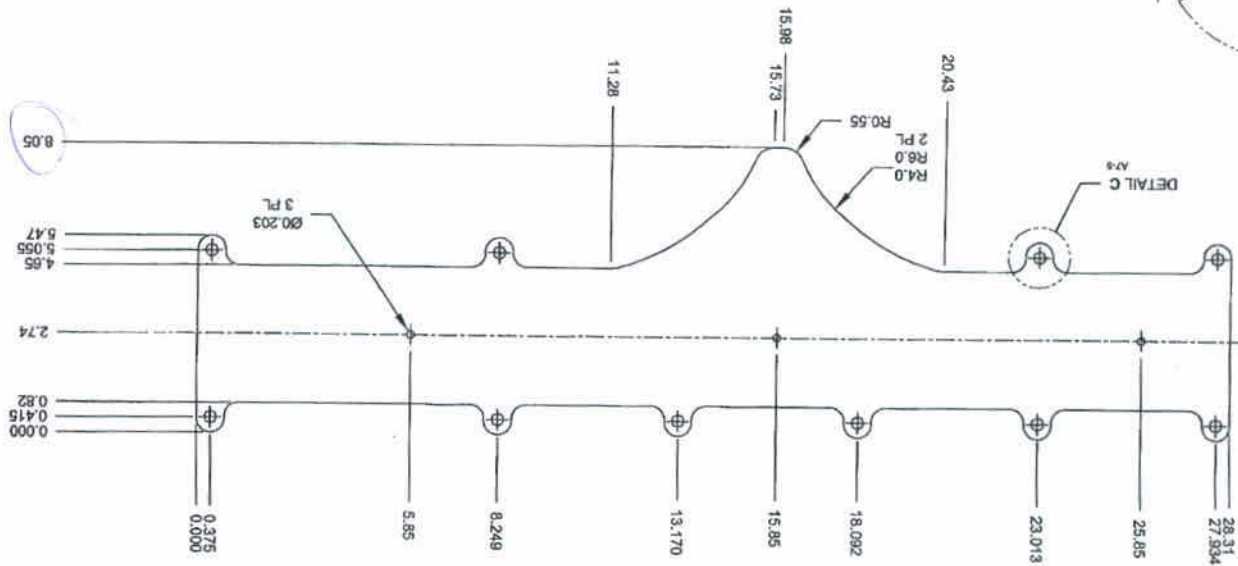
- NOTES:
- 1) MATERIAL: AISI 304 16 STAINLESS STEEL, PER AMS 5624 OR ASTM A240, 18 GAUGE (0.050 THICK)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 1.8 lbs

REF DART SPEC M304S18GA

DETAIL C  
SCALE 5X



D4134-1F FLAT PATTERN



*with collar*

RELEASED  
2010-06-23

DESIGN	DATE
DRAWN	10.06.15
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
TITLE	WEARPLATE, AFT
DRAWING NO.	D4134
REV. A	
SHEET 5 OF 6	
SCALE	
NTS	

DART AEROSPACE USA, INC  
PORT HADLOCK, WA



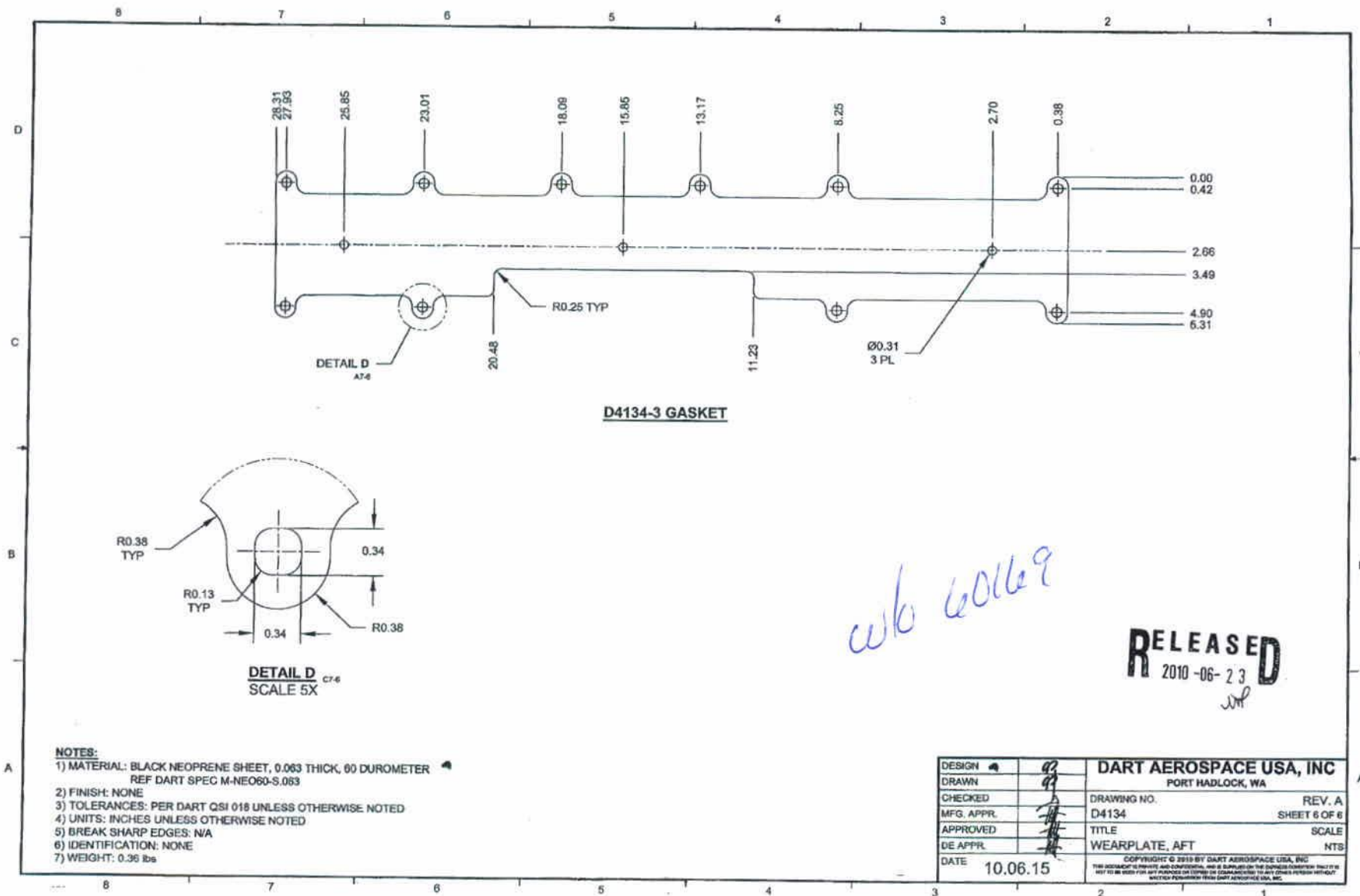
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries